

Date: Wednesday, 03/09/2008 10:26:07 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41723  
 Estimate Number : 12926  
 P.O. Number :  
 This Issue : 03/09/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 34603  
 Written By :  
 Checked & Approved By : JUL 08.9.03  
 Comment : Est Rev:A New Issue, 07-07-04 JLM

Drawing Name : 206/OH 58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
 REVIEW  
 Part Number : D29381UP  
 Drawing Number : D2938 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material :  
 Due Date : 26/09/2008 Qty: 3 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or. Operation: Description :

1.0 D6101003 Saddle Billet, 7075



Comment: Qty: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: 34873

8/5 08/09/08

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 5-Deburr

(P2)

ml / 8/5 08/09/08 (3)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

ml / 8/5 08/09/08 (3)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET


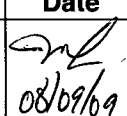

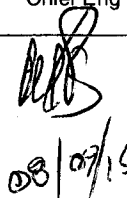

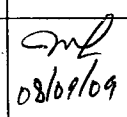

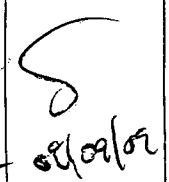


Comment: INSPECT ALL DIM TO DIM SHEET

ml 08/09/09 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-1 UP PAR #: NA Fault Category: Prod / Machined Part NCR: (Yes) No DQA: D Date: 08/09/09  
 Resolution: SCRAP Disposition:  QA: N/C Closed: D Date: 08/09/09

NCR: <u>41723</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/9	# 2.4	chatter <del>caused</del> caused the flat marring surface with skid mark hole under by 0.020" R.C. Part failed during Facing on 3rd opp.	 08/09/09	SCRAP of 08.09.09 and destroy and replace QTY (X) 2 D# 34873	 08/09/09	 08/09/09	 08/09/09	 08/09/09
08.09.09	2	BORSE TO SKIDTUBE IS 0.099" THICK IN ONE AREA	CP 08.09.09 PC 05/04/2	ACCEPTABLE: Affected area very small. QTY (X) 1	 08/09/09	 08/09/09	CP 08.09.09 PC 05/04/2	 08/09/09

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:26:07 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 41723

Part Number: D29381UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 08/09/15 (X3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 08-09-16

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-P 08/09/16 (30)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 444

JS 08/09/17 (X3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/18

Job Completion



MF 08-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41723	
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2938-1	
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>	

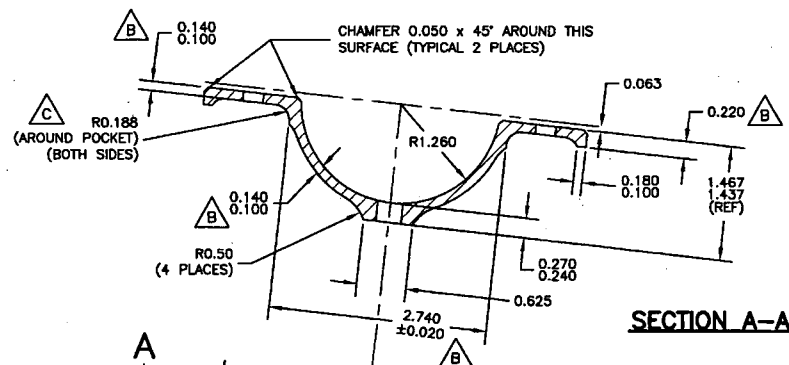
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.123	.132			
B	0.100	0.140		.127	.123	.132			
C	0.100	0.140		.108	.100	.115			
D	0.210	0.230		.220	.220	.220			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.50	.50	.51			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.316	.316	.316			
M	0.235	0.240		.238	.238	.239			
N	0.100	0.140		.110	.110	.110			
O	0.540	0.560		.550	.550	.550			
P	0.490	0.510		.501	.503	.503			
Q	3.715	3.725		3.717	3.717	3.717			
R	2.720	2.760		2.740	2.740	2.740			
S	0.240	0.270		.250	.250	.233			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.633	1.633	1.633			
V	1.362	1.372		1.370	1.370	1.370			
W	0.316	0.321		.321	.321	.321			
X	1.250	1.270		1.260	1.260	1.260			
Y	1.565	1.585		1.570	1.570	1.575			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

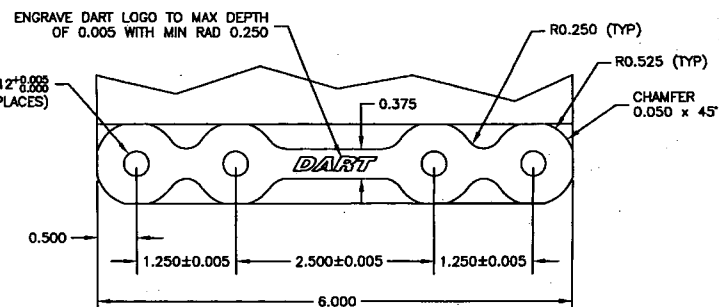
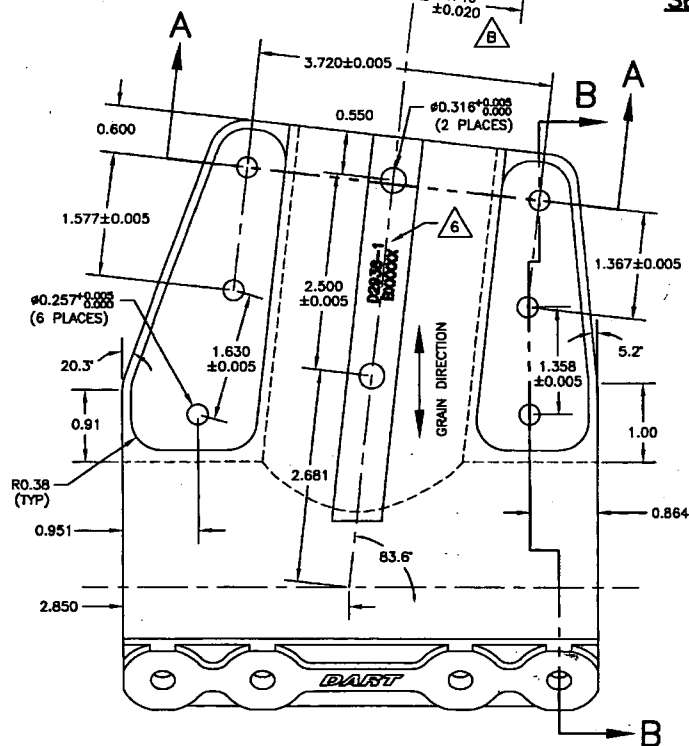
Measured by: *SP*  
Date: *08/07/08 / 08/09/09*

Audited by: *S*  
Date: *08/09/15*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

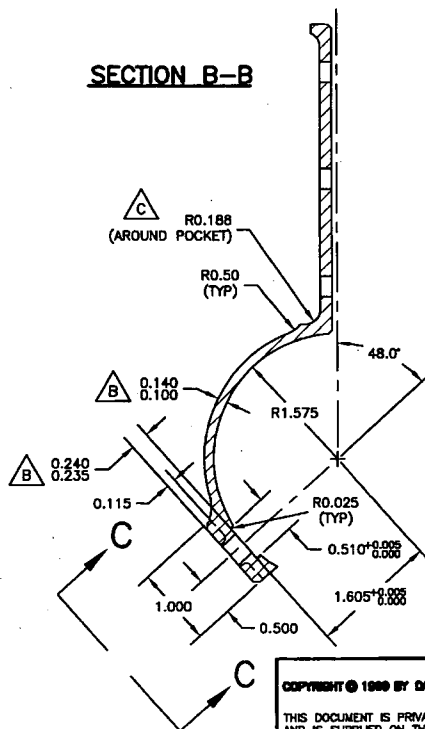


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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**DART** DART AEROSPACE USA, INC.  
BELLEVUE, WA

DRAWING NO. D2938  
SHEET 1 OF 1

2.3

NO. 41703  
WORK ORDER  
SUBJECT TO A AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

07.02.12